

Date: Thursday, 16/10/2008 10:45:36 AM
 User: Julie Dawson

Process Sheet

| | | | |
|----------------------------------|--|-------------------------|--|
| Customer | : CU-DAR001 Dart Helicopters Services | Drawing Name | : BASKET BASE ASSEMBLY (350) |
| Job Number | : 42630C | | |
| Estimate Number | : 10189 | | |
| P.O. Number | : | Part Number | : D2221 |
| This Issue | : 16/10/2008 S.O. No. : | Drawing Number | : D2221 REV G |
| Prsht Rev. | : NC | Project Number | : N/A |
| First Issue | : // Type : LARGE FAB ASSY | Drawing Revision | : G |
| Previous Run | : 42628C | Material | : |
| Written By | : | Due Date | : 11/11/2008 Qty: 1 Um: Each |
| Checked & Approved By | : <u>SUO 08-10-16</u> | | |
| Comment | : Est Rev:J 05.09.02 Added D3442-1 KJ/JLM Est Rev:K 08-08-29 revG as per dwg DD verified by:EC Est Rev:L 08-09-24 plug holes prior to powder coat :DD verified by:EC | | |

Additional Product

Job Number:



| | | |
|----------------|------------------------------|----------------------|
| Seq. #: | Machine Or Operation: | Description : |
|----------------|------------------------------|----------------------|

| | | |
|-----|--------|-------------|
| 1.0 | D31661 | Basket Hoop |
|-----|--------|-------------|



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

| | | | |
|---|---------|-----|-------|
| 4 | D3166-1 | RIB | 42716 |
|---|---------|-----|-------|

SAD 08-11-13 ①

| | | |
|-----|--------|--------------|
| 2.0 | D22323 | Basket Hinge |
|-----|--------|--------------|



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

| | | | |
|---|---------|---------------|--------|
| 2 | D2232-3 | Hinge bracket | 639334 |
|---|---------|---------------|--------|

11/08/17 ①

| | | |
|-----|-------|-----------------------------|
| 3.0 | D2325 | Support Gusset (350 Basket) |
|-----|-------|-----------------------------|



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

| | | | |
|---|-------|----------------|------------------------|
| 4 | D2325 | Support Gusset | 1x 638741 3x 639913 |
|---|-------|----------------|------------------------|

11/08/17

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
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NOTE: Date & initial all entries

Date: Thursday, 16/10/2008 10:45:36 AM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET BASE ASSEMBLY (350)

Job Number: 42630C

Part Number: D2221

Job Number:



| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|
|---------|-----------------------|---------------|

| | | |
|-----|--------|----------------|
| 4.0 | D23273 | Spacer Bushing |
|-----|--------|----------------|



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

| Qty | Part Number | Description | Batch |
|-----|-------------|-------------|-------|
|-----|-------------|-------------|-------|

| | | | |
|-----|---------|---------|--|
| ✓ 2 | D2327-3 | Bushing | |
|-----|---------|---------|--|

B29560

M 08/11/17

| | | |
|-----|-------|------------------|
| 5.0 | D2581 | Mounting Bracket |
|-----|-------|------------------|



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

| Qty | Part Number | Description | Batch |
|-----|-------------|-------------|-------|
|-----|-------------|-------------|-------|

| | | | |
|-----|-------|------------------|--|
| ✓ 2 | D2581 | Mounting Bracket | |
|-----|-------|------------------|--|

B40895

M 08/11/17

| | | |
|-----|--------|------|
| 6.0 | D34421 | Shim |
|-----|--------|------|



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

| Qty | Part Number | Description | Batch |
|-----|-------------|-------------|-------|
|-----|-------------|-------------|-------|

| | | | |
|-----|---------|------|--|
| ✓ 2 | D3442-1 | Shim | |
|-----|---------|------|--|

B40392

M 08/11/17

| | | |
|-----|--------------|------------------------|
| 7.0 | M304EX07516F | Expanded Metal Flat SS |
|-----|--------------|------------------------|



Comment: Qty.: 41.6745 sf(s)/Unit Total: 41.6745 sf(s)

Pick:

| Qty | Part Number | Description | Batch |
|-----|-------------|-------------|-------|
|-----|-------------|-------------|-------|

| | | | |
|------------|----------------|----------------|--|
| ✓ 39.69 sf | M304EX0.75-16F | Expanded Metal | |
|------------|----------------|----------------|--|

M109383

M 08/11/19

| | | |
|-----|----------------|---------------------------|
| 8.0 | M304TS0750W065 | 304 SQ Tube .75x.75x.065W |
|-----|----------------|---------------------------|



Comment: Qty.: 29.4000 f(s)/Unit Total: 29.4000 f(s)

Pick:

28" 3/4" x 3/4" x 0.065 wall 304/316 SS tubing

Batch: M108846 (8)

M109737 (2.4)

SAD 08-11-13

(P)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET BASE ASSEMBLY (350)

Job Number: 42630C

Part Number: D2221

Job Number:



Seq. #:

Machine Or Operation:

Description :

9.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut D2235-1 Rib from D3166-1 Rib As Per Dwg D2235

2-Drill hole in D2221-3 as per Dwg D2221

3-Deburr

4-Remove all markings on material before welding

5-Weld as per Dwg D2221 using Welding Table and corner JigDeburr as required

08/11/20
SJD 08/11/21

10.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

11.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

500/11/24 (40)

12.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

1- Plug holes in D2581 prior to powder coating

2-Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

1ST COAT:

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

***** 2nd coat if necessary*****

2ND COAT:

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

3:40
4:00
4:10

M-K 08/11/24 (1X)

7:30
8:00
8:00

M-K 08/11/25 (1X)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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Job Number: 42630C

Part Number: D2221

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

508/11/05 (20)

14.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/11/26

Job Completion



mf 08-11-25

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

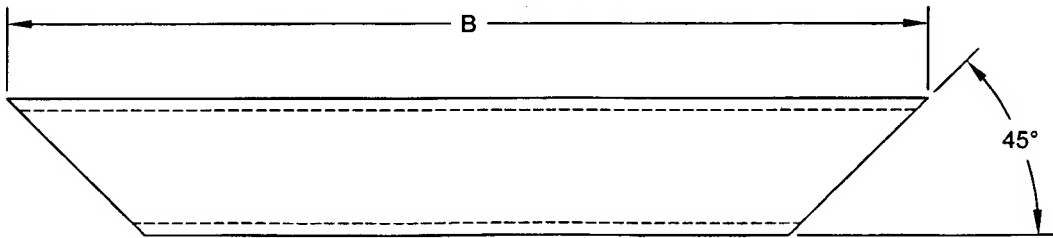
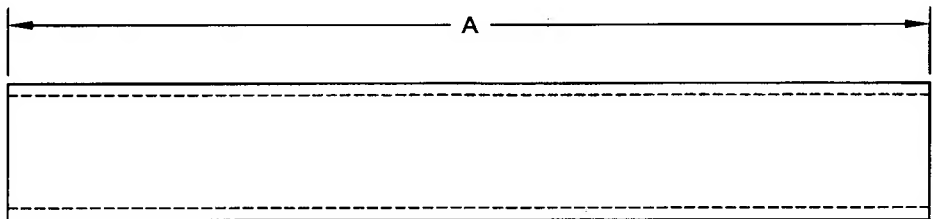
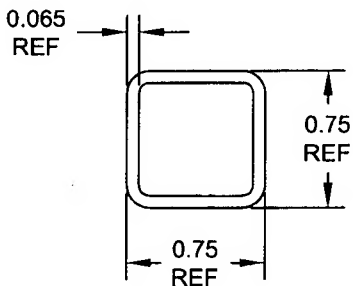
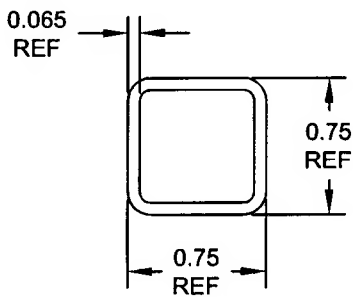
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

PARTS LIST FOR D2221 BASKET BASE ASSEMBLY

| PART NO | QUANTITY | LENGTH A | LENGTH B | DESCRIPTION |
|---------|----------|-------------|-------------|------------------|
| D2221-1 | 2 | _____ | 96.00 | RIB |
| D2221-3 | 2 | _____ | 25.50 | RIB |
| D2221-5 | 2 | 18.88 | _____ | RIB |
| D2221-7 | 1 | 55.25 | _____ | RIB |
| D2232-3 | 2 | N/A | N/A | HINGE PLATE |
| D2235-1 | 4 | N/A | N/A | RIB |
| D2325 | 4 | N/A | N/A | SUPPORT GUSSET |
| D2327-3 | 2 | N/A | N/A | BUSHING |
| D2581 | 2 | N/A | N/A | MOUNTING BRACKET |
| D3442-1 | 2 | N/A | N/A | SHIM |



D2221-1/-3/-5/-7

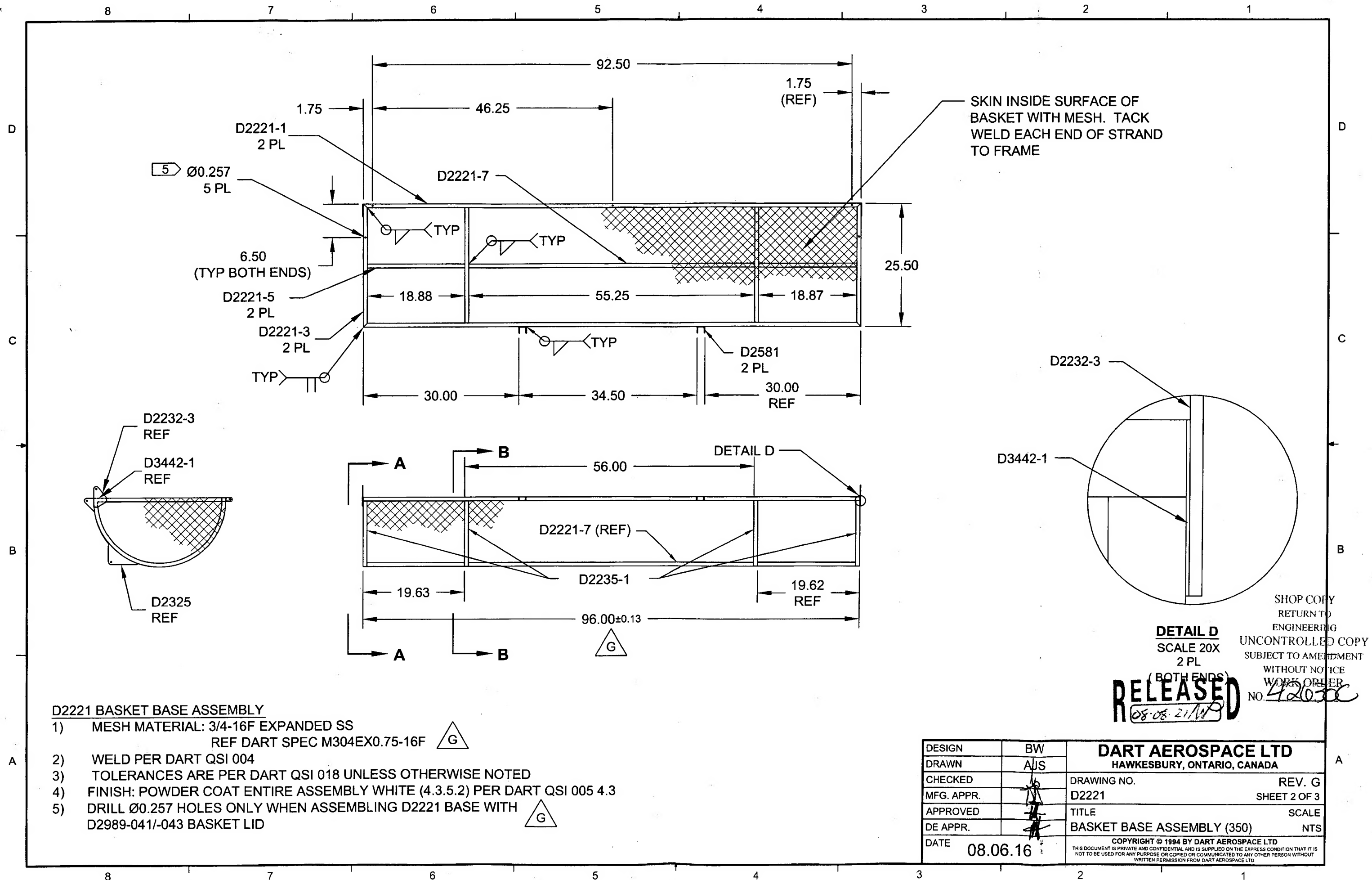
- 1) CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST
- 2) MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X 0.065 WALL SQUARE TUBING
REF. DART SPEC M304TS0.750W.065
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

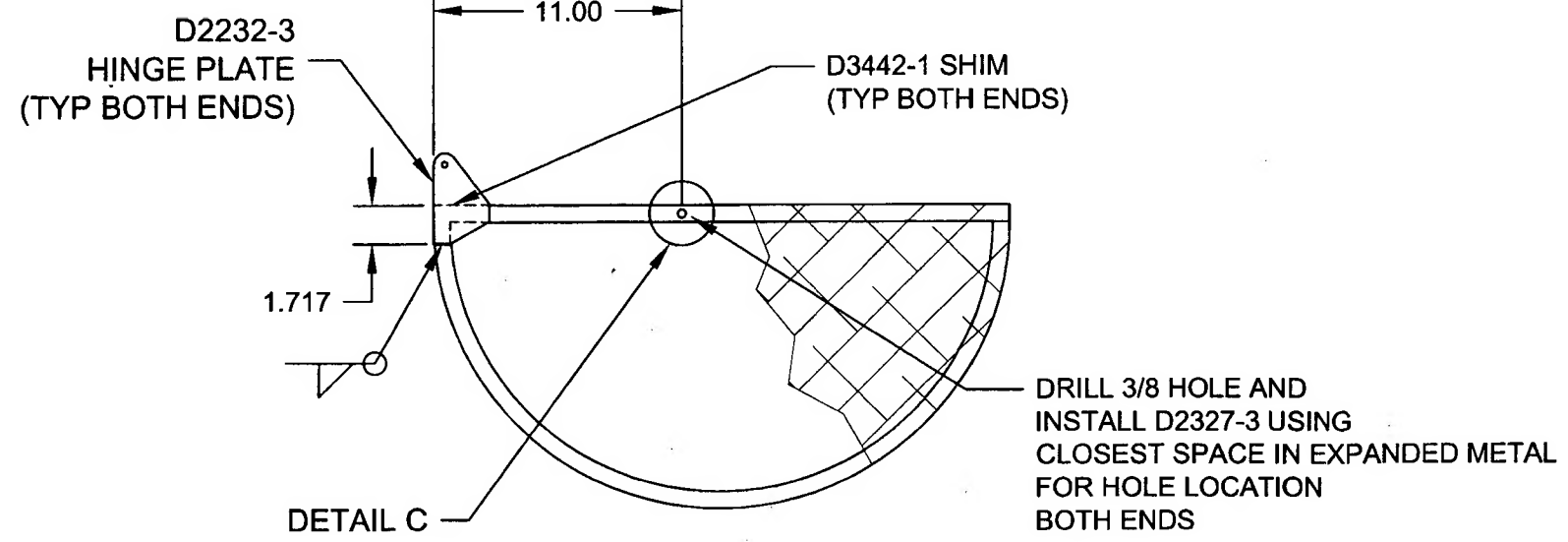


RELEASED

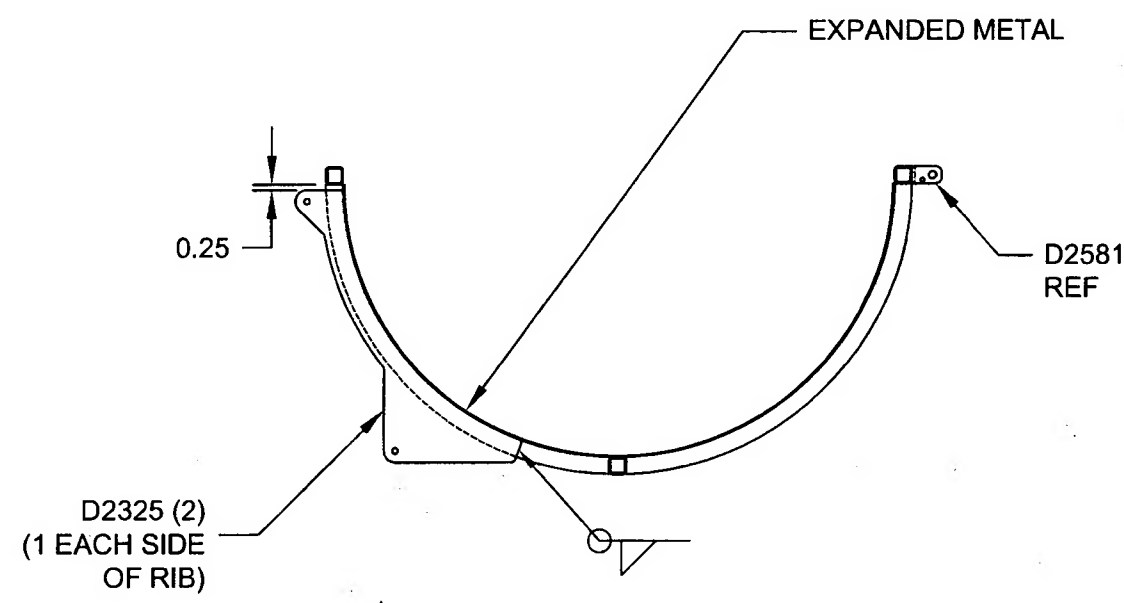
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 42030

| | | | |
|------------|--|--|--------------|
| G | MATERIAL FOR -1, -3, -5, & -7 WAS 0.060 WALL. SHT 2 ZN B,5 TOLERANCE FOR 96.00 DIM WAS +/- 0.01, 56.00 DIM WAS REF. SHT 2 ZN B4 19.62 DIM WAS "HARD" DIMENSION IS NOW REF. NOTE 5 TRANSFERED FROM SHT 1 TO SHT 2. SHT 2 MESH MATERIAL UPDATED. DRAWING TRANSFERED TO "B" FORMAT. | AJS | 08.06.16 |
| F | ADD SHIM UNDER HINGES. ADD HOLES FOR SPLIT LID BASKETS | PH | 05.06.07 |
| E | CHANGE HINGE | CP | 01.04.19 |
| D | CHANGE LATCH | BW | 96.06.21 |
| C | SEPERATE BASKET AND LID | KH | 95.11.21 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | BW | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | AJS | | |
| CHECKED | | DRAWING NO. | REV. G |
| MFG. APPR. | | D2221 | SHEET 1 OF 3 |
| APPROVED | | TITLE | SCALE |
| DE APPR. | | BASKET BASE ASSEMBLY (350) | NTS |
| DATE | 08.06.16 | COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD. | |

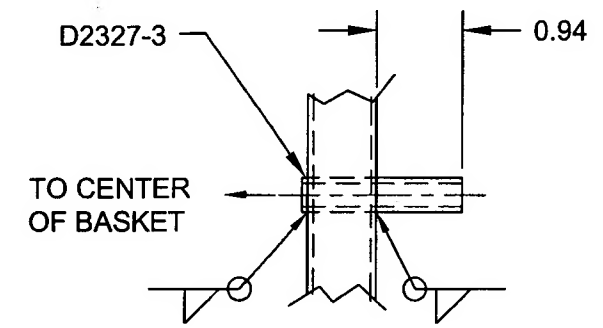




SECTION A-A SAME BOTH END RIBS



SECTION B-B SAME BOTH CENTER RIBS



**DETAIL C
SCALE 4X**

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 42630C

RELEASED
08-08-27/11

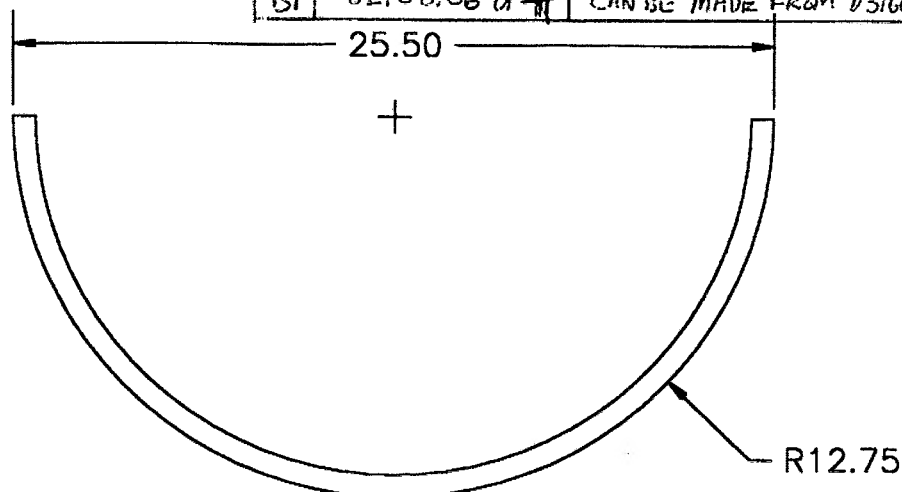
| | | | |
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| DESIGN | BW | DART AEROSPACE LTD | |
| DRAWN | AJS | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | | DRAWING NO. | REV. G |
| MFG. APPR. | | D2221 | SHEET 3 OF 3 |
| APPROVED | | TITLE | SCALE |
| DE APPR. | | BASKET BASE ASSEMBLY (350) | NTS |
| DATE | 08.06.16 | <small>COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small> | |

DART

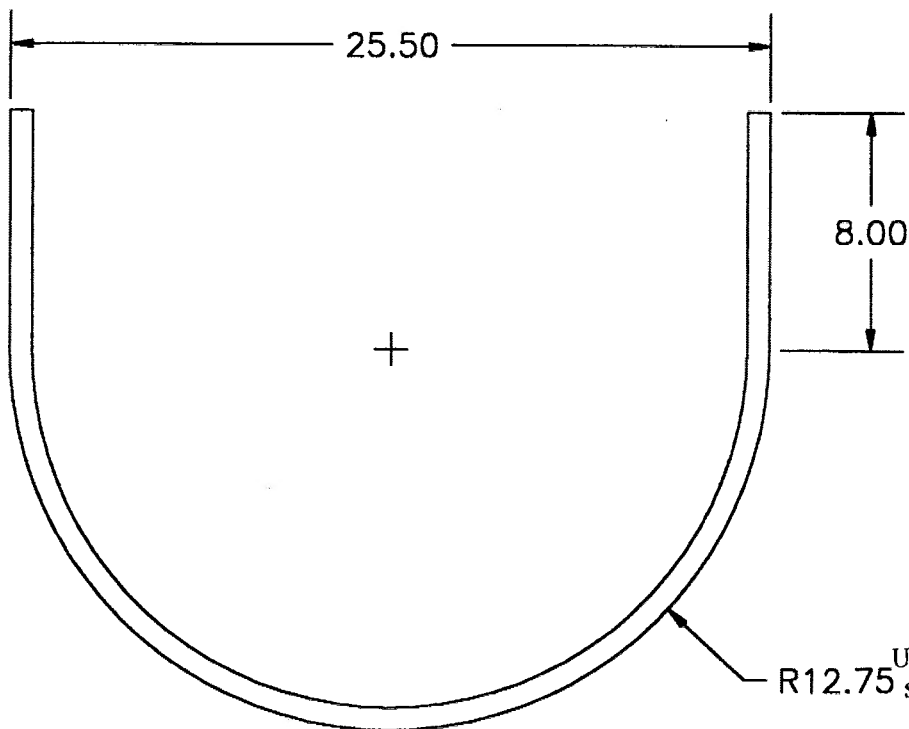


| | | | |
|------------|---------------|--|--------------|
| DESIGN | DRAWN BY | DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA | |
| B WILLIAMS | B WILLIAMS | DRAWING NO. | REV. B |
| CHECKED | APPROVED | D2235 | SHEET 1 OF 1 |
| DATE | TITLE | SCALE | |
| 94:12:16 | BASKET RIBS | | |
| BI | 02.08.06 (P#) | CAN BE MADE FROM D3166-1 | |

RELEASED
R 960507



D2235-1



D2235-3

CAN BE MADE FROM D3166-1 (BI)
MATERIAL: 304/316 SS, 3/4 X 3/4 X 0.063 WALL SQR.

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 12630